Rev A 13/12/24

Wôrk Order ID 110500

December-23-13 9:52:01 AM

110500 PRELIMINARY TOOL

Item ID: D5022-3
Revision ID: PRELIM
Item Name: Foam

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 12/23/13 **Start Qty:** 1.00 *1*
Required Date: 12/23/13 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D5022 — Revision Nbr: ~~PA2~~ Rev A — DAS 27 9-89 — DAS 10 9-89									
110		0.00							
110		0.00				1	EL	13-12-23	
Waterjet	**Memo**								
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: PA1 Prog Rev: PA1 2-Deburr if necessary								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120		0.00				1		~~EB~~	13/12/23
QC	**Memo**								
Quality Control									

Item ID: D5022-3 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: PRELIM **Stop** *NS2*
Item Name: Foam

Start Date: 12/23/13 **Start Qty:** 1.00 *1*
Required Date: 12/23/13 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				1			
130 QC Quality Control	**Memo**	0.00				Inspect as per Dwg PA2			
140	Identify as per dwg & Stock Location:	0.00							
140 Packaging Packaging	**Memo**	0.00							
150	QC21- Final Inspection - Work Order Release	0.00							
150 QC Quality Control	**Memo**	0.00							

DAS 27 9-89 13/12/23

WO 110506 D4635-143

MLJ 14-01-24

DAS 27 9-89 13/12/24 Release Dwg Rev A 12.13.12.23

CORRECTIVE RECALL 13.12.23 AUTH

DATE 13/12/24

Picklist Print

December-23-13 9:52:01 AM

Work Order ID: **110500**

Parent Item: **D5022-3** **Start Date:** 12/23/13 **Required Date:** 12/23/13

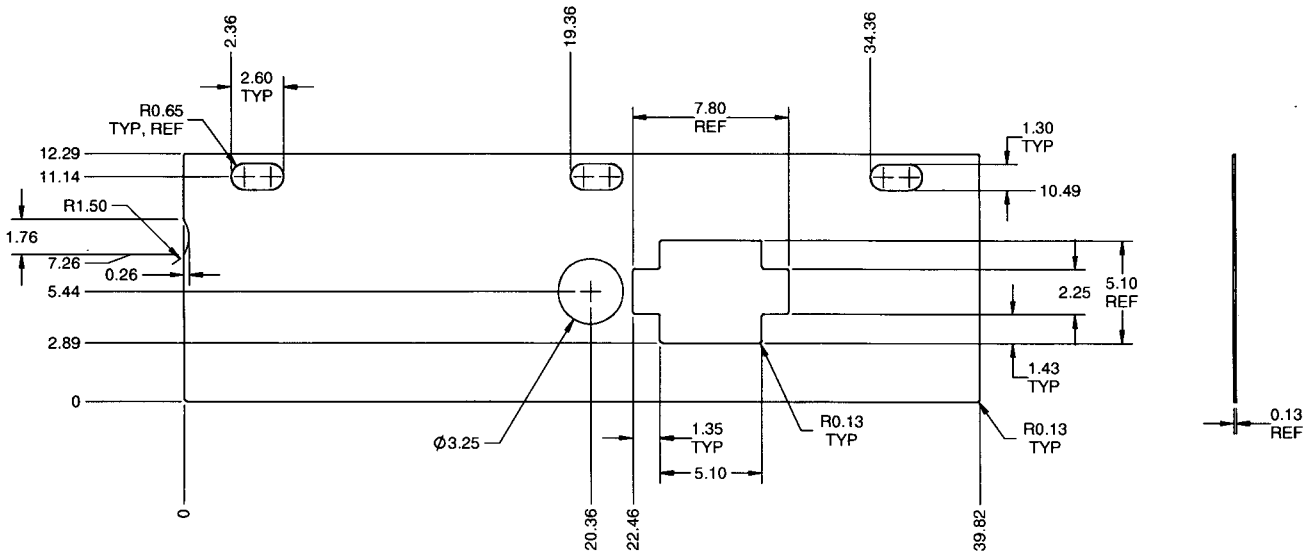
Parent Item Name: Foam **Start Qty:** 1.00 **Required Qty:** 1.00

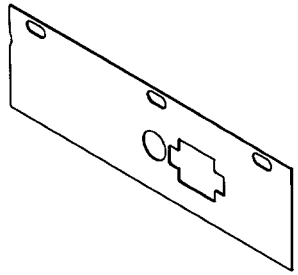
Comments: IPP REV:A 13.12.20 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5033-1 Rigid Polyurethane Foam		Manufactured	No				sf	0.0000		5			

EJ 13-12-23

B110489 x 8 square feet





PRELIMINARY ISSUE

~~A~~ 13.12.09

D5022-3 FOAM, SIDE PANEL, AFT

NOTES:
1) MATERIAL: D5033-1 (RIGID POLYURETHANE FOAM)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.19 lbs

W/O 110500

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D5022 REV. PA2
CHECKED	BC	SHEET 2 OF 3
MFG. APPR.		TITLE FOAM CORE SCALE NTS
APPROVED		
DE APPR.		
DATE	13.12.09	

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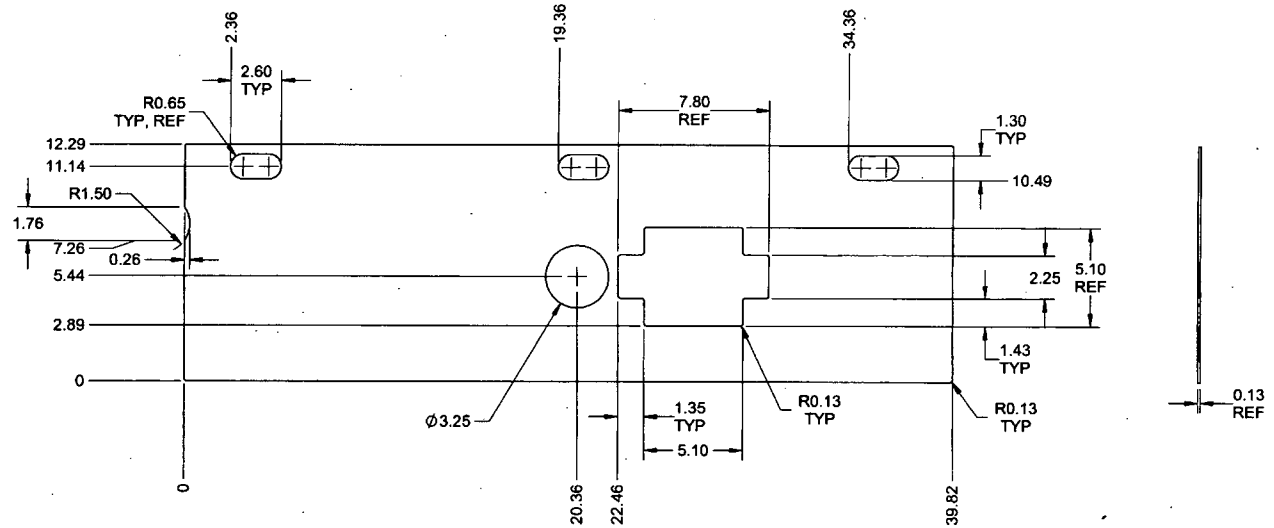
DART AEROSPACE LTD	Work Order:	Blanks
Description: Side Panel aft	Part Number:	DS022-3
Inspection Dwg: DS022 Rev: PA2		Page 1 of 1

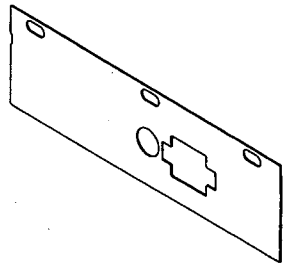
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.30	+/- 0.030	12.30	✓			JKM-06
11.14	+/- "	11.20	✓			"
5.44	+/- "	5.50	✓			"
2.89	+/- "	2.89	✓			"
1.35	+/- "	1.35	✓			"
5.10	+/- "	5.10	✓			"
7.80	+/- "	7.80	✓			"
39.82	+/- "	39.80	✓			"
1.30	+/- "	1.30	✓			"
2.60	+/- "	2.60	✓			"
20.36	+/- "	20.40	✓			"
22.46	+/- "	22.45	✓			"
10.49	+/- "	10.50	✓			"
3.25	+/- "	3.24	✓			JKM-05

Measured by: DAS 27 9-89	Audited by:	Preliminary Approval:
Date: 13.10.05	Date:	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	





RELEASED
2013-12-23
ASS

D5022-3 FOAM, SIDE PANEL, AFT

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DESIGN	RF
DRAWN	RF
CHECKED	SC
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	13.12.09

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D5022 REV. A
SHEET 2 OF 3
TITLE FOAM CORE
SCALE NTS

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